

# Work Order ID 74354



Page 1

Wednesday, September 28, 2011 3:25:33 PM

Item ID:	D2661-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle, RH Fwd Aft Out 206					
Start Date:	9/28/2011	Start Qty:	20.00		Cust Item ID:	
Required Date:	10/7/2011	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan: <u>M.L.J</u>	Date: <u>11/09/20</u>	Tooling:		Date:		Run	Start	
	QC:	Date:	SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2661	Rev D								

100		HAAS CNC VERTICAL MACHINING #1	0.00	<u>B.A 11/10/11</u>		<u>20</u>	<u>0</u>		
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HAAS 1  
HAAS CNC vertical machine #1

**Memo**  
Program part number and batch number. ☐ Fixturing Inspection last completed 11/10/11 by B.A ☐ 1-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet ☐ 2-Machine Step No 2 of Folio and visually inspect as per attached Dimension

110		CONVENTIONAL MILLING MACHINE	0.00	<u>B.A 11/10/12</u>		<u>20</u>	<u>0</u>		
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Mill Conv  
Conventional Milling Machine

**Memo**  
Machine Keyway and inspect per attached dimension sheet

120		QC2- Inspect parts off machine FAI/FAIB	0.00	<u>B.A 11/10/11</u>		<u>20</u>	<u>0</u>		
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QC  
Quality Control

**Memo**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 74354



Page 2

Wednesday, September 28, 2011 3:25:33 PM

Item ID:	D2661-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle, RH Fwd Aft Out 206					
Start Date:	9/28/2011	Start Qty:	20.00		Cust Item ID:	
Required Date:	10/7/2011	Req'd Qty:	20.00		Customer:	
Reference:	1					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		SL 11-10-13		20	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				20	BL	11-10-13	
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo	0.00 0.00							

START TIME: 8:30  
FINISH TIME: 9:00  
OVEN TEMPERATURE:

20X 9 M/L 11/10/18

M117745

3200F

9:00

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 74354**

Wednesday, September 28, 2011 3:25:33 PM

Page 3

Item ID: D2661-2

Accept

Revision ID:

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/28/2011 Start Qty: 20.00

Required Date: 10/7/2011 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

206  
count 11/10/18

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

11/11/18 (20)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/18  
MF  
11-10-18

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, September 28, 2011 3:25:41 PM

Work Order ID: 74354



Parent Item: D2661-2



Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/28/2011

Required Date: 10/7/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC  
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	73.0000	1	20			

Saddle Billet, 7075

Location	Loc Qty	Loc Code
MAT040	8	
72226	8	
MAT44	65	
72226	5	
✓73769	60	

20.0

M.A 10/10/11

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>7435Y</b>
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b>	<b>D2661-2</b>
<b>Inspection Dwg:</b> D2661 Rev. D		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.112	.112	.112	.110		
B	0.100	0.140		.110	.110	.110	.111		
1.125-1.245	<del>1.250</del>	<del>1.270</del>		1.134	1.134	1.134	1.135		
D	0.615	0.685		.675	.675	.675	.675		
E	0.240	0.260		.245	.245	.247	.247		
1.313-1.343	<del>1.437</del>	<del>1.467</del>		1.319	1.319	1.319	1.319		
G	0.210	0.230		.220	.220	.221	.221		
H	0.100	0.180		.135	.130	.132	.130		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.574	1.573	1.573	1.573		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.111	.112	.112	.111		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.571	.571	.572	.572		
O	5.990	6.010		5.999	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.315	.315	.315	.315		
S	0.315	0.322		.317	.317	.317	.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.363	1.362	1.363	1.362		
V	0.787	0.807		.796	.794	.796	.794		
W	0.540	0.560		.549	.546	.545	.544		
X	1.674	1.684		1.680	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.921	.921	.919	.921		
AA	0.490	0.510		.499	.500	.500	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>SMJ</i>
Date:	11/10/11

Audited by:	<i>JL</i>
Date:	11-10-13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 74354
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b> D2661-2
<b>Inspection Dwg:</b> D2661 Rev. D		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				Date
				5	6	7	8	
A	0.100	0.140		.112	.111	.112	.114	
B	0.100	0.140		.110	.110	.110	.110	
C	<del>1.250</del>	<del>1.270</del>		1.133	1.134	1.134	1.134	
D	0.615	0.685		.675	.675	.675	.675	
E	0.240	0.260		.247	.247	.247	.247	
F	<del>1.437</del>	<del>1.467</del>		1.319	1.319	1.319	1.319	
G	0.210	0.230		.218	.219	.219	.220	
H	0.100	0.180		.135	.135	.135	.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	
J	1.565	1.585		1.573	1.571	1.572	1.572	
K	0.235	0.240		.238	.238	.238	.238	
L	0.100	0.120		.114	.112	.113	.113	
M	0.990	1.010		1.000	1.000	0.999	0.999	
N	0.510	0.515		.512	.512	0.513	0.513	
O	5.990	6.010		6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.313	0.318		.315	.315	.315	.315	
S	0.315	0.322		.317	.317	.317	.317	
T	2.495	2.505		2.500	2.500	2.500	2.500	
U	1.357	1.367		1.363	1.362	1.362	1.362	
V	0.787	0.807		.793	.793	.794	.794	
W	0.540	0.560		.543	.545	.546	.544	
X	1.674	1.684		1.680	1.679	1.679	1.679	
Y	0.257	0.262		.257	.258	.258	.258	
Z	0.912	0.932		.922	.922	.919	.921	
AA	0.490	0.510		.500	.500	0.499	0.499	
AB	0.178	0.198		.188	.188	.188	.188	
AC								
AD								
AE								
AF								
Accept/Reject								

Measured by: <i>[Signature]</i>
Date: 11/10/11

Audited by: <i>[Signature]</i>
Date: 11-10-13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 74354
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b> D2661-2
<b>Inspection Dwg:</b> D2661 Rev. D		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	10	11	12		Date
A	0.100	0.140		0.112	0.112	0.113	0.112		
B	0.100	0.140		0.110	0.110	0.110	0.114		
C	<del>1.250</del>	<del>1.270</del>		1.134	1.132	1.134	1.137		
D	0.615	0.685		0.675	0.675	0.675	0.675		
E	0.240	0.260		0.248	0.252	0.250	0.249		
F	<del>1.437</del>	<del>1.467</del>		1.322	1.322	1.322	1.323		
G	0.210	0.230		0.220	0.221	0.220	0.222		
H	0.100	0.180		0.135	0.135	0.135	0.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.572	1.571	1.573	1.575		
K	0.235	0.240		0.238	0.238	0.238	0.238		
L	0.100	0.120		0.111	0.111	0.111	0.111		
M	0.990	1.010		0.999	0.999	0.999	0.999		
N	0.510	0.515		0.513	0.513	0.513	0.513		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.315	0.315	0.315	0.315		
S	0.315	0.322		0.317	0.317	0.317	0.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.795	0.795	0.795	0.796		
W	0.540	0.560		0.545	0.552	0.550	0.549		
X	1.674	1.684		1.679	1.680	1.679	1.679		
Y	0.257	0.262		0.258	0.258	0.258	0.258		
Z	0.912	0.932		0.923	0.919	0.920	0.919		
AA	0.490	0.510		0.498	0.498	0.500	0.500		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>H.A. / ml</u>	Audited by: <u>SL</u>
Date: <u>11/10/12</u>	Date: <u>11-10-13</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

UNCLASSIFIED

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>74358</b>
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b>	<b>D2661-2</b>
<b>Inspection Dwg:</b> D2661 Rev. D		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				Date
				13	14	15	16	
A	0.100	0.140		0.112	0.112	.111	.112	
B	0.100	0.140		0.111	0.111	.111	.111	
C	<del>1.250</del>	<del>1.270</del>		1.134	1.133	1.135	1.135	
D	0.615	0.685		0.675	0.675	0.675	0.675	
E	0.240	0.260		0.250	0.250	.248	.248	
F	<del>1.437</del>	<del>1.407</del>		1.322	1.322	1.323	1.322	
G	0.210	0.230		0.220	0.220	.221	.220	
H	0.100	0.180		0.135	0.135	0.135	0.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	
J	1.565	1.585		1.5725	1.572	1.5735	1.573	
K	0.235	0.240		0.238	0.238	0.238	0.238	
L	0.100	0.120		0.111	.111	.111	.111	
M	0.990	1.010		0.999	0.999	0.999	0.999	
N	0.510	0.515		0.512	0.512	0.512	0.512	
O	5.990	6.010		6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.313	0.318		0.315	0.315	0.315	0.315	
S	0.315	0.322		0.317	0.317	0.317	0.317	
T	2.495	2.505		2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	
V	0.787	0.807		.795	.796	.795	.799	
W	0.540	0.560		.549	.550	.549	.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	
Y	0.257	0.262		0.258	0.258	0.258	0.258	
Z	0.912	0.932		.919	.919	.921	.919	
AA	0.490	0.510		0.502	.500	.499	.499	
AB	0.178	0.198		0.188	0.188	0.188	0.188	
AC								
AD								
AE								
AF								
Accept/Reject								

Measured by:	<i>B.A. / [Signature]</i>
Date:	<i>11/10/12 / 11/10/12</i>

Audited by:	<i>[Signature]</i>
Date:	<i>11-10-13</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 74358
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b> D2661-2
<b>Inspection Dwg:</b> D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	17	18	19	20		Date
A	0.100	0.140		.111	.112	.112	.112		
B	0.100	0.140		.111	.111	.111	.111		
C	<del>1.250</del>	<del>1.270</del>		1.135	1.135	1.134	1.135		
D	0.615	0.685		.675	.675	.675	.675		
E	0.240	0.260		.248	.248	.247	.248		
F	<del>1.437</del>	<del>1.467</del>		1.320	1.320	1.320	1.320		
G	0.210	0.230		.221	.220	.221	.220		
H	0.100	0.180		.130	.135	.135	.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.574	1.572	1.572	1.572		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.111	.110	.110	.111		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.511	.511	.511	.511		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.315	.315	.315	.315		
S	0.315	0.322		.317	.317	.317	.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.794	.795	.795	.796		
W	0.540	0.560		.546	.545	.544	.545		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.920	.920	.920	.920		
AA	0.490	0.510		.499	.502	.501	.499		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

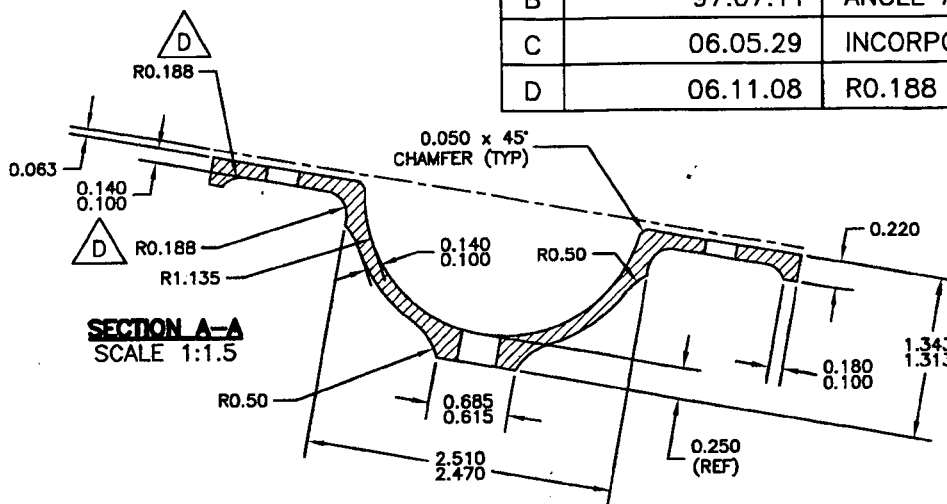
Measured by: <i>[Signature]</i>
Date: 11/10/12

Audited by: <i>[Signature]</i>
Date: 11-10-13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	<i>[Signature]</i>

**DART**

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2661	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE OUTSIDE	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	



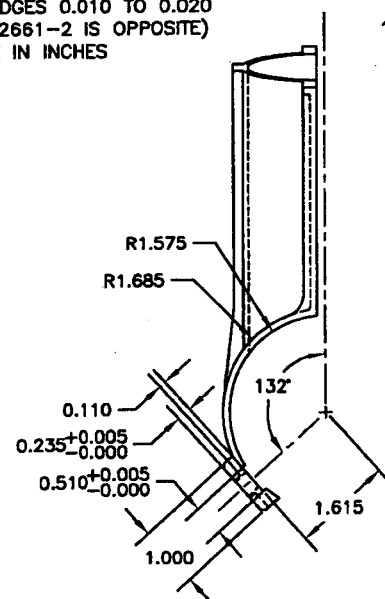
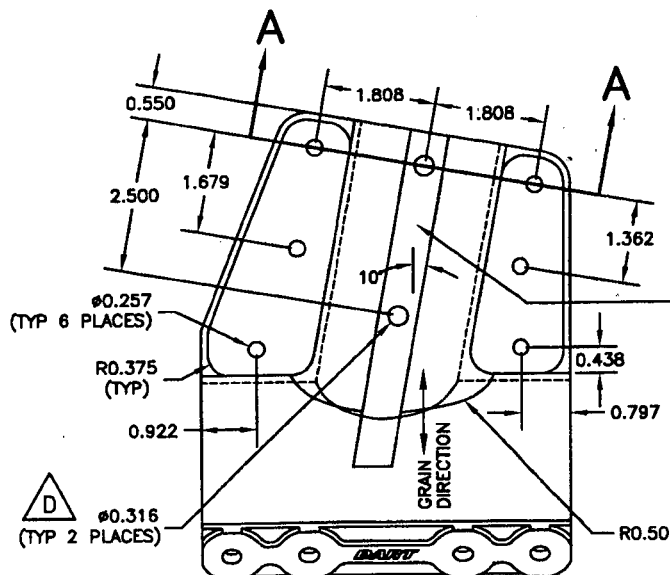
RELEASED

07-02-12 #

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WORK ORDER

## NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (60-A-250/12) (MAKE FROM D6101-003 SADDLE-BILLET-7075).
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2661-1 SADDLE OUTSIDE**

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries